

Date: Friday, 9/21/2007 1:01:27 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WHEEL SHAFT
Job Number	: 34795	Part Number	: D33341
Estimate Number	: 10449	Drawing Number	: D3334 REV. B1
P.O. Number	: <i>N/A</i>	Project Number	: N/A
This Issue	: 9/21/2007 S.O. No. : <i>N/A</i>	Drawing Revision	: B1
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>NA</i> Type : MACHINED PARTS	Due Date	: 10/8/2007
Previous Run	: 30953	Qty:	<i>14</i> Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: B 05.03.02 Revised material; Added Powder Coat K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4140HR3500	4140 Heat Treated Bar
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Comment: Qty.: 0.6563 f(s)/Unit Total : 6.5630 f(s)

4140 HEAT TREATED BAR

Material: AISI 4140 or ASTM A304-02/A-434-BC/A193-03-Grade-B7/A29-03/A322-91 or UNS# G41400

(M4140H-R3.500)

Batch: *M105801*

3.2 07/10/15

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI

1- Cut blanks: Ø3.500" Bar to 7.750" long - *3.2 07/10/15*

2- Turn as per Folio FA492 and Dwg D3334

3- Deburr

[Signature] 07/10/18

16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07/10/18

16

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS1

Machine as per Folio FA492 and Dwg D3334

Identify as D3334-1

3.5 07/11/15

[Signature] 07-11-14

(14)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07-11-14 (14)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:01:27 PM
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Drawing Name: WHEEL SHAFT

Job Number: 34795

Part Number: D33341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JA 07-11-16

(14)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask thread and bearing surface

M18052

m.f 07/11/19

(14X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 07/11/19 (14)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST494

AS

07/11/19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(14) 07/11/19

Job Completion



07-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

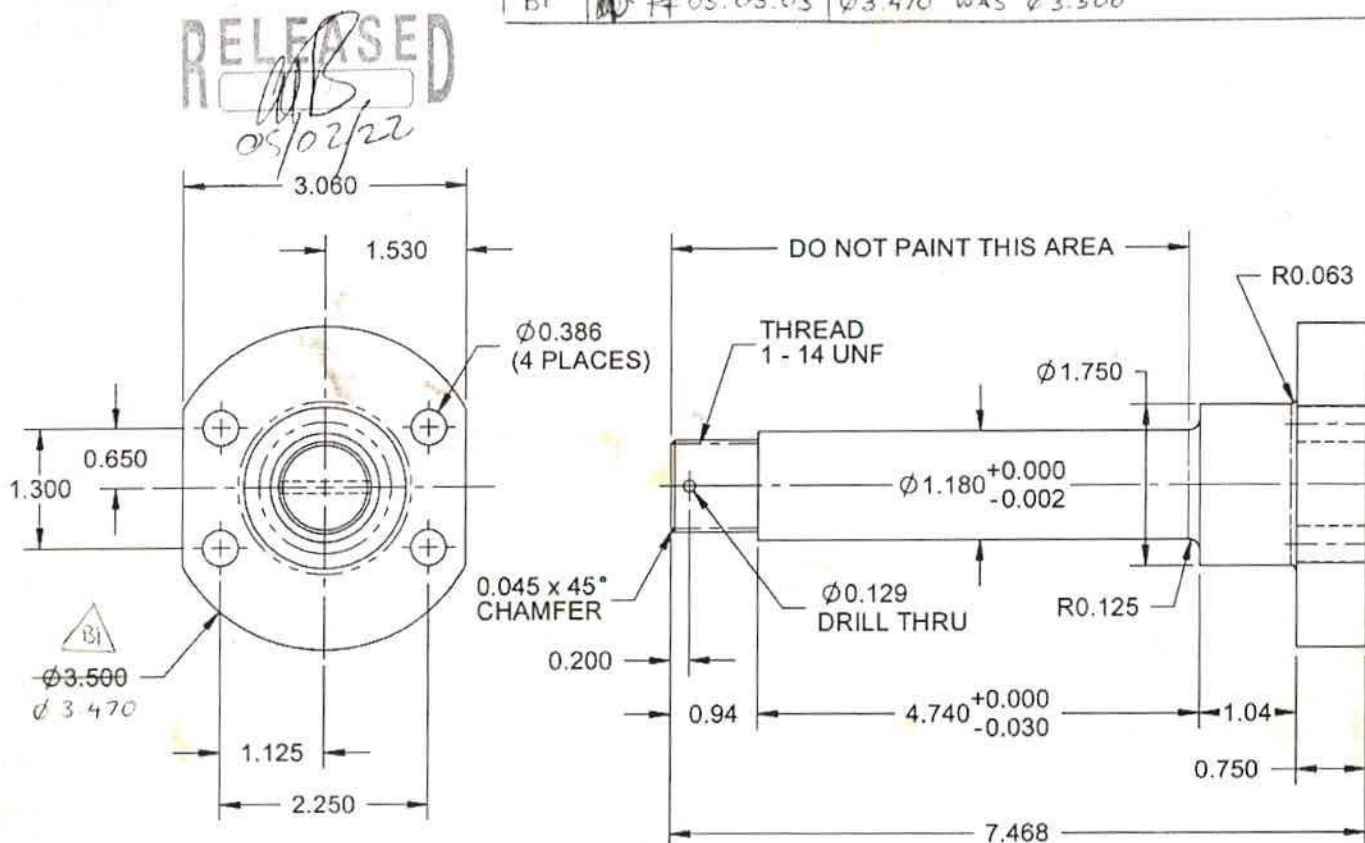
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3334	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE WHEEL SHAFT	SCALE 1:2
A	04.12.16	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	
BI	05.03.03	Ø 3.470 WAS Ø 3.500	

**D3334-1 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03-GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 (REF. DART SPEC. M4140H-R3.500)
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **34795**

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